

Work Order ID 68698

Wednesday, April 20, 2011 8:25:42 AM

Page 1

Item ID: D3208-7

Accept

Setup Start

Revision ID:

Stop

Item Name: Filler

Start Date: 4/20/2011 Start Qty: ~~10.00~~ ¹²

Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 4/20/2011

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3208	Rev A1

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut blank: 2.750" x 4.300" Identify for D3208-7

SB 11/05/10

12

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Drill and Fillet D3208-7 corner as per Dwg D3208 Identify as D3208-7

SB 11/05/10

12

120

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr D3208-7 Polish any marks on part within 01. of Dwg D3208

SB 11/05/10

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68698

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Page 2

Item ID: D3208-7

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Setup Start



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Stop



Item Name: Filler

Start Date: 4/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



0.00 *8 w/o 10*

QC

Memo

(12)

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



0.00

HandFinish

Memo

12 *✓* *M-L 11/05/10*

Hand Finishing

150

QC3- Inspect Part Finish

0.00



0.00

QC

Memo

12 *BL* *105-10.*

Quality Control

W/O:		WORK ORDER CHANGES						
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Page 3

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Accept

Revision ID:

Item Name: Filler

Start Date: 4/20/2011 Start Qty: 10.00

Required Date: 4/25/2011 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 202

0.00



Packaging

Memo

0.00

Packaging

11/5/10 SP (12)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11 CMF
11-05-11

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 20, 2011 8:25:48 AM

Page 1

Work Order ID: 68698



Parent Item: D3208-7



Parent Item Name: Filler

Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B04.05.25 Material changed for Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.040		Purchased	No			100	sf	95.5000	0.0902	0.949474			
--------------	--	-----------	----	--	--	-----	----	---------	--------	----------	--	--	--



2024-T3 .040 sheet

SD 11/05/10

Location	Loc Qty	Loc Code
MAT022	95.5	
112291	0.5	
112331	31	
113162	64	

1.1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

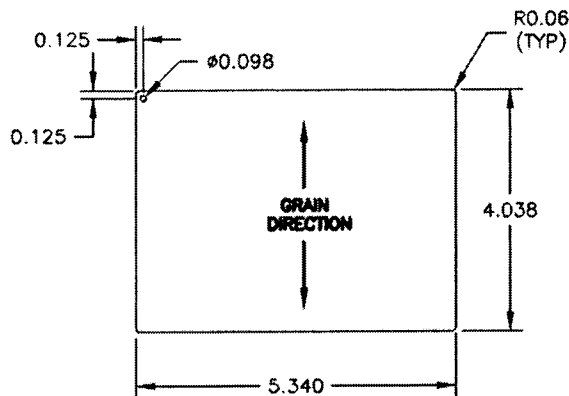
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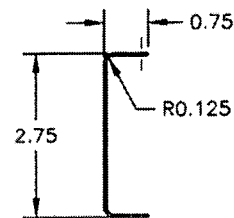


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DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
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AI	04.03.25	CHANGE DIM, NOTE 3) CHANGE	

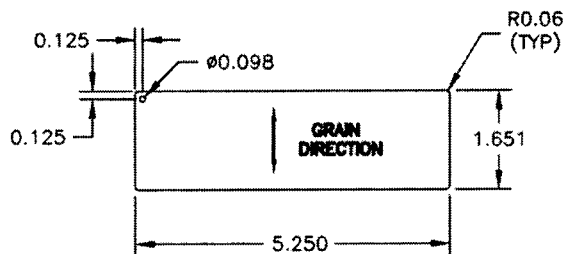
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04.04.05



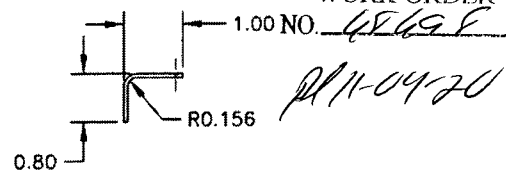
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

AI 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)

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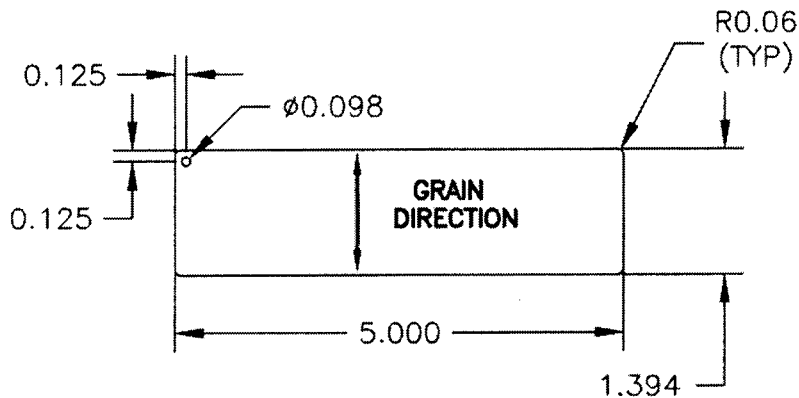
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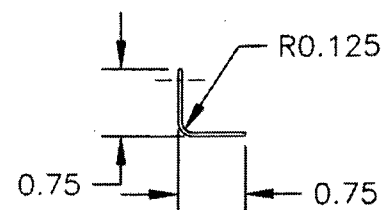


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CHECKED FF	APPROVED FF	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.04.05

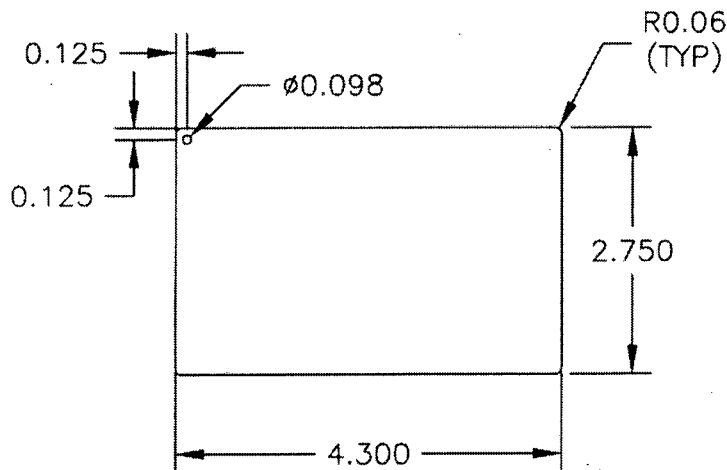


2 D3208-5 MOUNT ANGLE
FLAT PATTERN

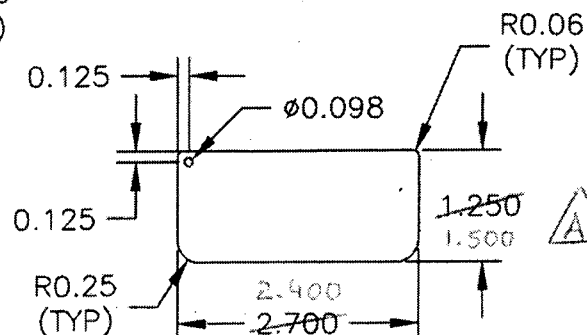


D3208-5 MOUNT ANGLE
BEND DETAIL

W/O GRAB



2 D3208-7 FILLER



2 D3208-11 FILLER

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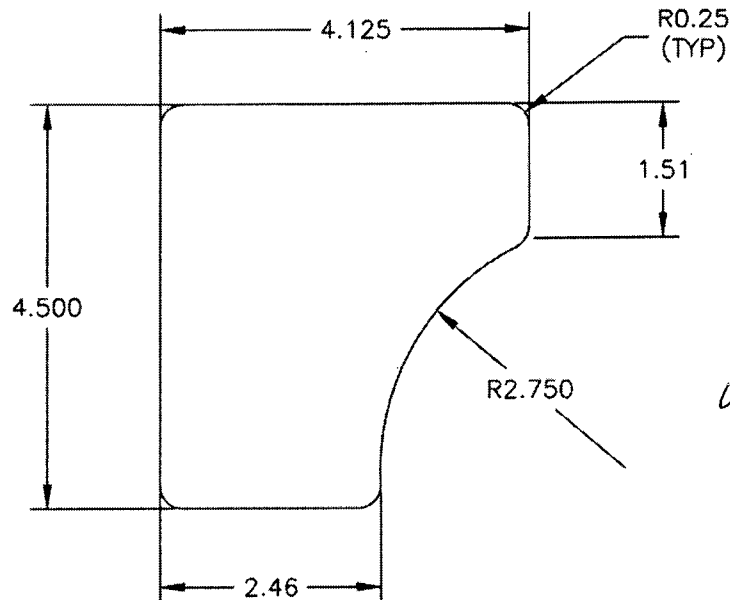
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.04.05 *[Signature]*



D3208-9 DOUBLER

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